

Work Order ID: 62223

Page 1

Wednesday, September 22, 2010 3:14:25 PM

Item ID: D3580-1

Accept



Setup Start



Revision ID:

Item Name: Joggle Bracket

Stop



Start Date: 9/22/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 9/29/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 10-9-23

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
D3580	Rev B	

100 Waterjet FLOW WATER JET 0.00



Waterjet FLOW WATER JET

Memo

0.00

10-9-30

FLOW CNC Waterjet 304 . 050 0.00

1-Cut as per Dwg D3580

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

(SG)

110 QC2- Inspect parts off machine FAI/FAIB 0.00

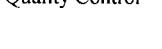


Memo

0.00

10-9-30

QC Quality Control 0.00



Memo

0.00

120 QC8- Inspect parts - second check 0.00



Memo

JU-03

0.00

59

100-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 9/29/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center ID

130

Operation
Description

Small Fab

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Small Fab

Small Fab

Memo

Bend as per dwg D3580 using 1/8" offset die

SB 10/10/25

59

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

SB 10/10/25

counters

x59

150



Packaging

Packaging

Identify as per dwg & Stock Location: 66

0.00

Memo

0.00

C10/10/26 (59)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Item ID: D3580-1

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Setup

Start



Revision ID:

Item Name: Joggle Bracket

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Start Date: 9/22/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 9/29/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

QC

Quality Control

Memo

0.00

10/10/26 JJ

MF

10-10-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, September 22, 2010 3:14:29 PM

Work Order ID: 62223



Parent Item: D3580-1



Parent Item Name: Joggle Bracket

Start Date: 9/22/2010

Required Date: 9/29/2010

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev :A New Issue 07.06.25 EC
IPP Rev:B Removed Powder Coat 07-07-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA 		Purchased		No		100	sf	127.9479	0.01	0.421053	7	1810-9-30	

304/316 .050 Sheet

Location	Loc Qty	Loc Code
MAT20	127.9479	
111743	7.36	
112885	10.4179	
113062	58.17	
115389	52	

(12178)

(12178)

(59)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	62223
Description: Joggle Bracket	Part Number:	D3580-1
Inspection Dwg: D3580	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>BS</u>	Audited by: <u></u>	Prototype Approval: N/A
Date: <u>10-9-30</u>	Date: <u>1009.30</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.10.30	New Issue	KJ/EC/DD	

W/O:		WORK ORDER CHANGES							
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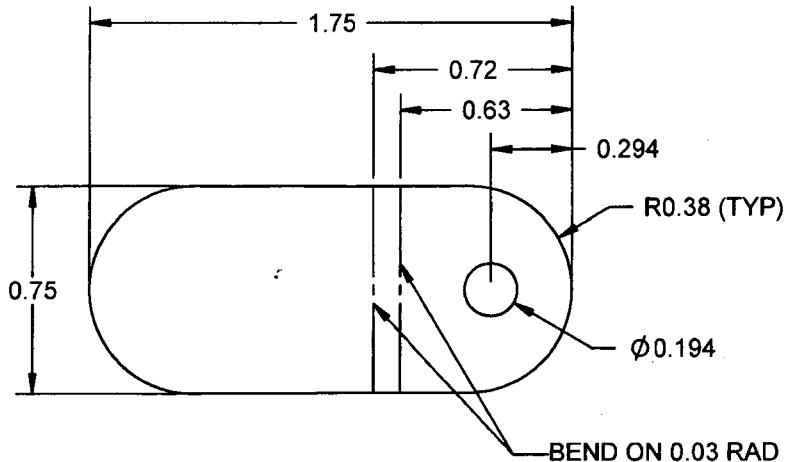
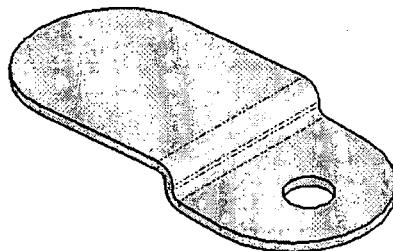
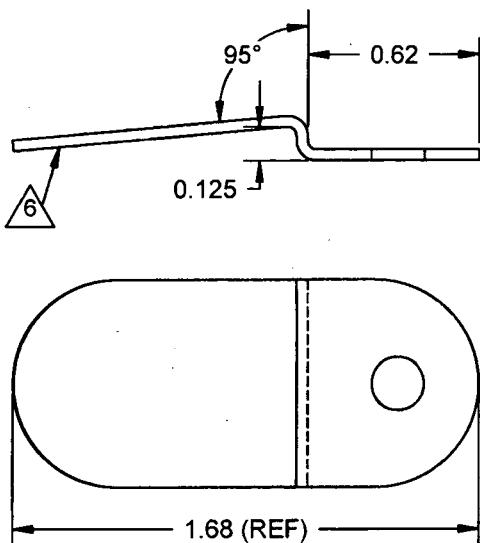
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DART

DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>CH</i>	DRAWING NO. D3580	REV. B SHEET 1 OF 1
DATE 07.07.09		TITLE JOGGLE BRACKET	SCALE 3:2
REV A	DATE 07.05.15	DESCRIPTION	
B	07.07.09	NEW ISSUE REMOVE POWDER COAT	

RELEASED07.07.09 *CH***D3580-1F FLAT PATTERN****D3580-1 JOGGLE BRACKET****NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK)
PER MIL-S-5019 (REF DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3580-1" USING FINE POINT PERMANENT INK MARKER
ON THE UNDERSIDE OF THE PART AS INDICATED

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